






Work Order ID 63079

Wednesday, October 20, 2010 11:46:50 AM



Page 1


Item ID: D3784-041 Accept  Setup Start 
Revision ID:  Stop 
Item Name: Seat Support Assembly, Center
Start Date: 10/20/2010 Start Qty: 5.00  Cust Item ID:
Required Date: 10/27/2010 Req'd Qty: 5.00  Customer:
Reference:


Approvals: Process Plan:  Date: 10/10/20 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3784	Rev B

100	Pick Kit	0.00
		
Packaging	Memo	0.00
Packaging		

110	Small Fab	0.00
		
Small Fab	Memo	0.00
Small Fab	1-assemble as per dwg D3784	

120	QC5- Inspect part completeness to step on W/O	0.00
		
QC	Memo	0.00
Quality Control		

ES 10/10/26 (5)

ES 10/10/26 (5)

S 10/10/26

(X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63079

Wednesday, October 20, 2010 11:46:50 AM

Page 2

Item ID: D3784-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Support Assembly, Center

Start Date: 10/20/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 10/27/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 242

0.00



Packaging

Memo

0.00

Packaging

10/10/27SP (58)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28
MF
10-10-27

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 20, 2010 11:46:54 AM

Page 1

Work Order ID: 63079

Parent Item: D3784-041

Parent Item Name: Seat Support Assembly, Center





Start Date: 10/20/2010

Required Date: 10/27/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R20  Screw		Purchased	No			110	Each	100.0000	2	10			
<div> <div>Location</div> <div>ST325</div> <div>113524</div> <div>114348</div> <div>114354</div> </div> <div> <div>Loc Qty</div> <div>100</div> <div>0</div> <div>50</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN960JD10L  Washer	NAS1149D0332J	Purchased	No			110	Each	0.0000	2	10			
<div> <div>Location</div> <div>ST251</div> <div>55380</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3763-041  End Fitting Assembly		Manufactured	No			110	Each	1.0000	1	5			
<div> <div>Location</div> <div>ST251A</div> <div>54315</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3763-045  End Fitting Assembly		Manufactured	No			110	Each	2.0000	1	5			
<div> <div>Location</div> <div>ST251A</div> <div>54315</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

ES 10/10/26
M114227 (10x)

ES 10/10/26
5

ES 10/10/26
B61831 (5x)

2
B62017 (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 20, 2010 11:46:54 AM

Page 2

Work Order ID: 63079

Parent Item: D3784-041

Parent Item Name: Seat Support Assembly, Center

Start Date: 10/20/2010

Required Date: 10/27/2010

Start Qty: 5.00

Required Qty: 5.00

D3770-1 Manufactured No

110 Each

12.0000

1

5



Tube



ES 10/10/26

Location

Loc Qty

Loc Code

ST248A

12

56569

6

62458

6

5

MS21042L3

Purchased No

110 Each

2,382.000

2

10



Nut



ES 10/10/26

Location

Loc Qty

Loc Code

ST300

2382

114523

49

114784

1333

115835

1000

10

Wednesday, October 20, 2010 11:46:55 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

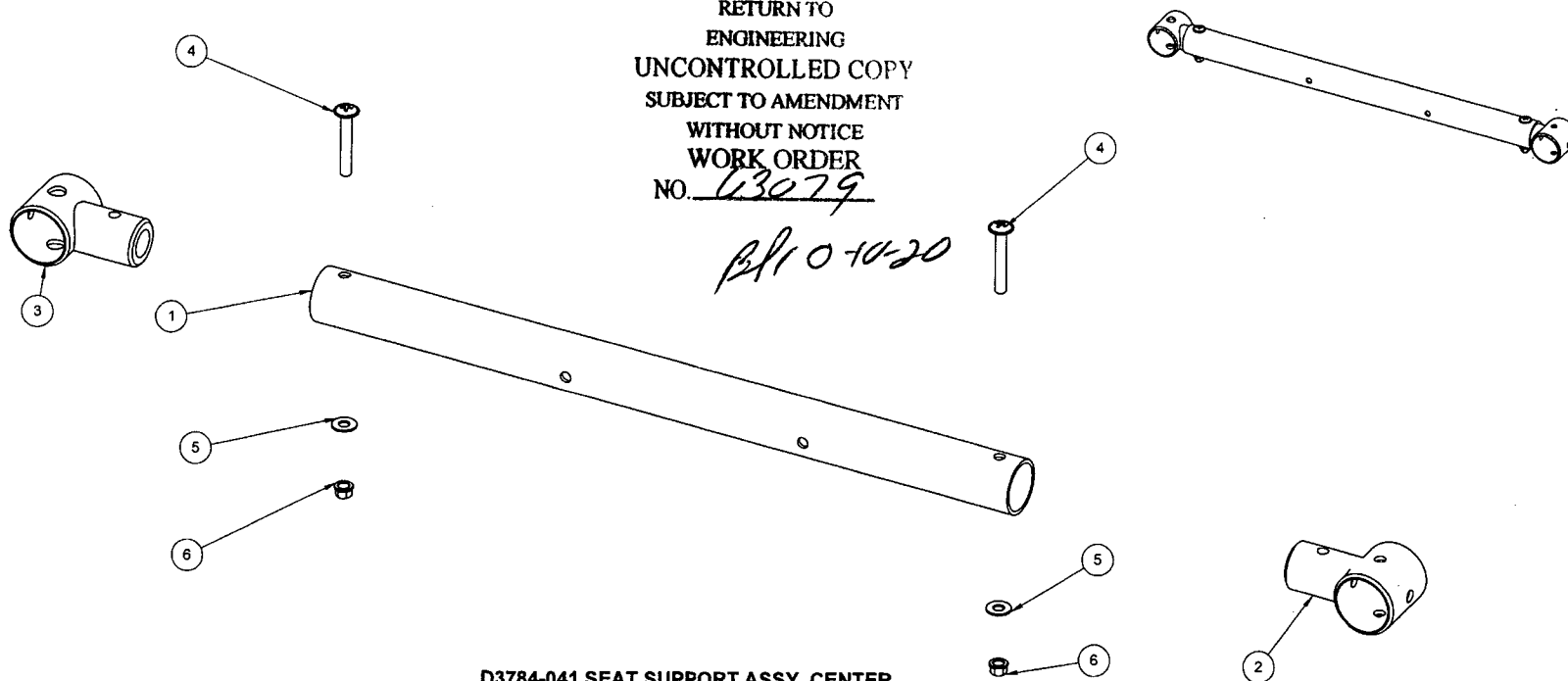
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 63079
BL 10-10-20



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED	HS		
MFG. APPR.	HS		
APPROVED	HS		
DE APPR.	HS		
DATE	08.06.23		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. **D3784**
 TITLE **SEAT SUPPORT ASSEMBLY**
 REV. B
 SHEET 1 OF 5
 SCALE
 NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

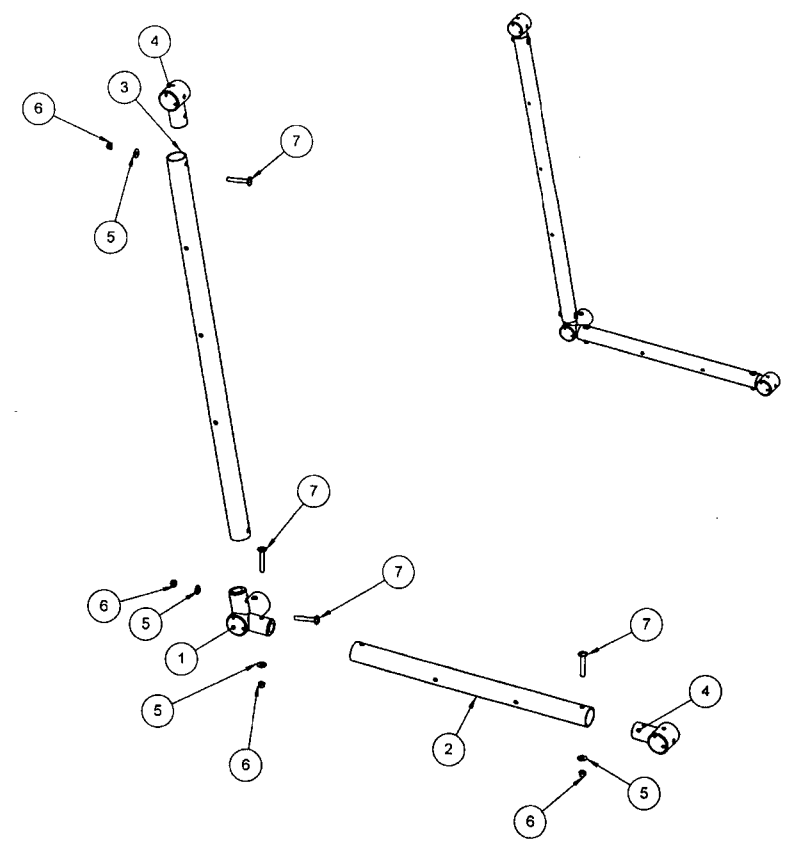
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 43079

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

△
B
△
B
△
B



D3784-043 SEAT SUPPORT ASSY, LH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>NO</i>	D3784	SHEET 2 OF 5
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.	<i>NO</i>	SEAT SUPPORT ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

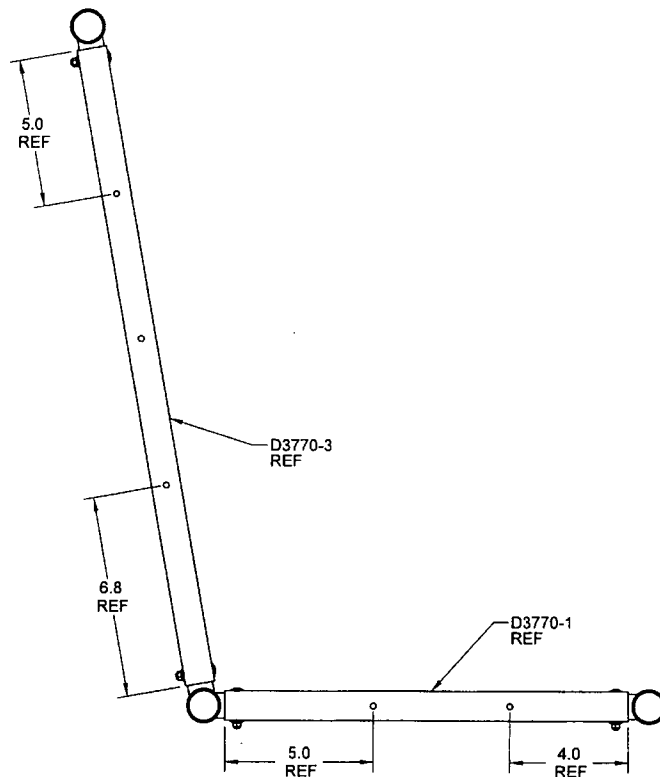
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/0 43079



D3784-043 SEAT SUPPORT ASSY, LH

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	HS	DRAWING NO. D3784	REV. B
MFG. APPR.		TITLE SEAT SUPPORT ASSEMBLY	SHEET 3 OF 5
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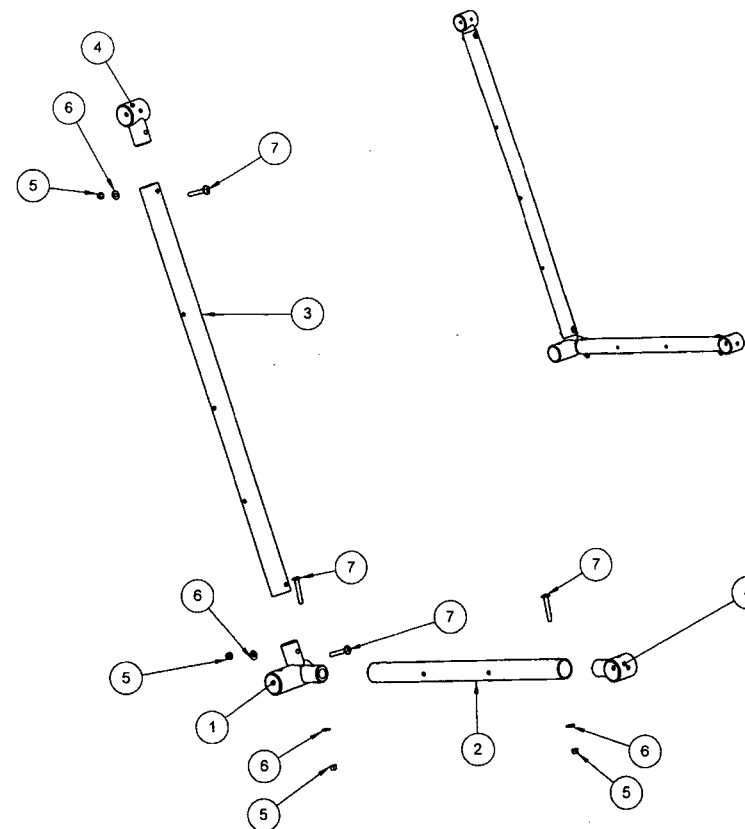
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W6 63079

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△B
△B
△B



D3784-044 SEAT SUPPORT ASSY, RH

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3784	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEAT SUPPORT ASSEMBLY	NTS
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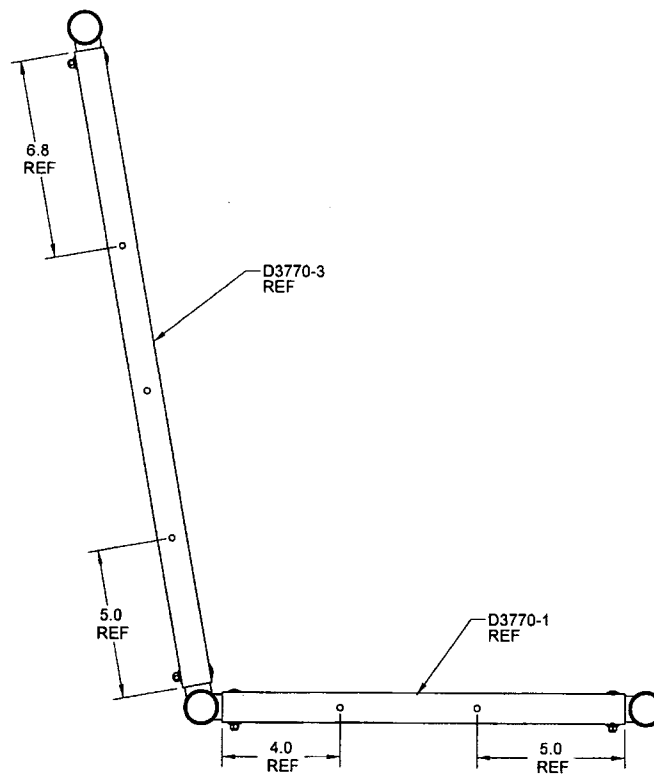
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W6 63579



D3784-044 SEAT SUPPORT ASSY, RH

RELEASED
08 07 15 1111

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3784	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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